

*Gray*

Date: Wednesday, 15/04/2009 9:48:57 AM  
User: Julie Dawson

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARSHOE
<b>Job Number</b> : 47211	
<b>Estimate Number</b> : 13315	
<b>P.O. Number</b> :	<b>Part Number</b> : D37933
<b>This Issue</b> : 15/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3793 REVA
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 45355	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 23/04/2009 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.04.17</u>	
<b>Comment</b> : Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-23 revA as per dwg DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S20GA	304/316 .040 Sheet
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**Comment:** Qty.: 1.3469 sf(s)/Unit Total: 16.1633 sf(s)  
304/316 .040 Sheet  
(M304S20GA)  
Batch: 111571 B 9-5-1

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3793  
Dwg Rev: A  
Prog Rev: 1

B 9-5-1

(15)

2-Deburr if necessary B 9-5-1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

B 9-5-1

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

508/05/04

(15)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

SB 09/08/04

(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 15/04/2009 9:48:57 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 47211

Part Number: D37933

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/04 (15)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

M109091

START TIME:

8:30

OVEN TEMPERATURE:

350

FINISH TIME:

9:00

BL 09-05-5

(15)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-05

(15)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FD-18

BL 09-05-5

(15)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/05

Job Completion



MF 09-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 49211
Description: Wearshoe		Part Number: D3793-3
Inspection Dwg: D3793	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

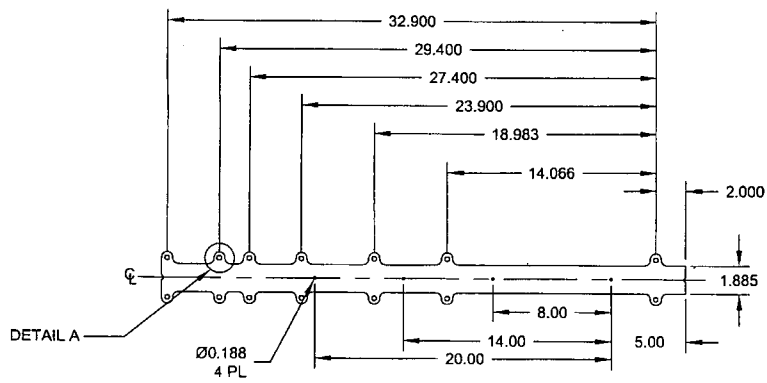
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.190	X			
0.300 x 0.300	+/-0.010	.302 x .303	X			
1.885	+/-0.010	1.889	X			
4.389	+/-0.010	4.390	X			
6.547	+/-0.010	6.545	X			
6.00	+/-0.030	6.00	X			
6.75	+/-0.030	6.75	X			
2.000	+/-0.010	2.001	X			
4.750	+/-0.010	4.750	0			
9.500	+/-0.010	9.500	X			
14.250	+/-0.010	14.250	X			
17.750	+/-0.010	17.750	X			
26.735	+/-0.010	26.735	X			
Ø0.531 x 0.780	+0.008/-0.001	.532 .781	X			

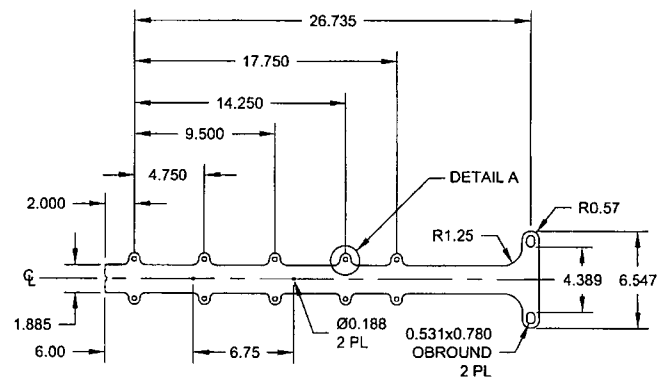
Measured by: HB	Audited by: S	Prototype Approval:	N/A
Date: 9-5-1	Date: 09/05/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

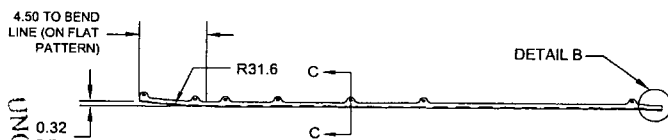
8 7 6 5 4 3 2 1



**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

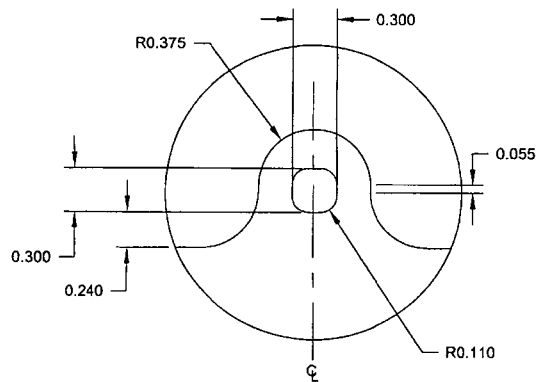
NO. 101  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCNTRILLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
  - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
  - 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

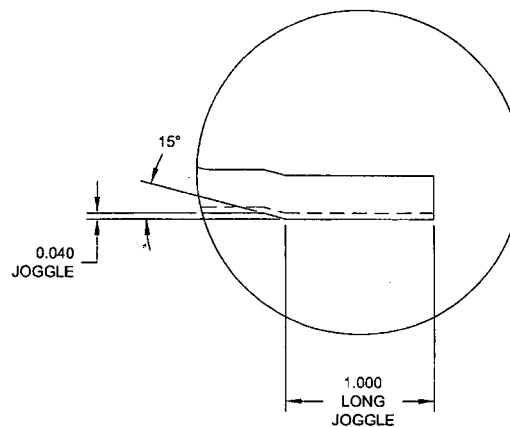
**RELEASED**  
08.05.14

A	NEW ISSUE		PH	08.05.14	
REV.		DESCRIPTION	BY	DATE	
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA			
DRAWN	PH				
CHECKED			DRAWING NO.	REV. A	
MFG. APPR.	DS		D3793	SHEET 1 OF 2	
APPROVED			TITLE	SCALE	
DE APPR.	PH		WEARSHOE	NTS	
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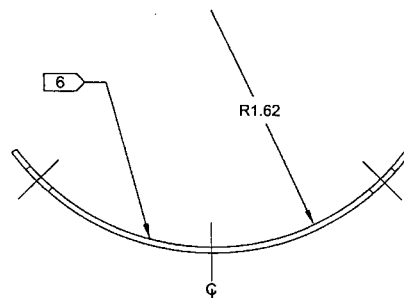
8 7 6 5 4 3 2 1



**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X



**SECTION C-C**  
SCALE 10X

**RELEASED**  
08-05-23 NED

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NO. 441211

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1